

Date: Wednesday, 15/04/2009 9:47:07 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : PROP ASSEMBLY
<b>Job Number</b> : 47186	
<b>Estimate Number</b> : 11558	
<b>P.O. Number</b> :	<b>Part Number</b> : D3085041
<b>This Issue</b> : 15/04/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3085 REV A1
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : SMALL / MED FAB	<b>Drawing Revision</b> : A1
<b>Previous Run</b> : 45557	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 27/04/2009 <b>Qty:</b> 4 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JUD 09.04.15</u>	
<b>Comment</b> : Est. B02.03.05 Added dwg Rev.A1 NG	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	D30153	Locknut
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Lock Nut

Pick:

Qty	Part Number	Description	Batch
1	D3015-3	Locknut	645394

9/5/13

SL

2.0	D30811	Hinge
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Hinge

Pick:

Qty	Part Number	Description	Batch
1	D3081-1	Prop Hinge	649081

9/5/13

9/5/13

3.0	D30821	Clip
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Clip

Pick:

Qty	Part Number	Description	Batch
1	D3082-1	Clip	47294

9/5/13

SL

4.0	D30841	Strut
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Strut

Pick:

Qty	Part Number	Description	Batch
1	D3084-1	Prop arm	643164

9/5/13

9/5/13

SL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PROP ASSEMBLY

Job Number: 47186

Part Number: D3085041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	AN45A	Bolt
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
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1	AN4-5A	Bolt	M109061
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9/5/13

SP

6.0	AN960JD10	Washer
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Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
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3	AN960JD10	Washer	MTH M111279
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9/5/13

SP

7.0	AN960JD10L	Washer
-----	------------	--------



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
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3	AN960JD10L	Washer	M109632
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9/5/13

SP

8.0	AN960JD416	Washer
-----	------------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
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2	AN960JD416	Washer	M110363
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9/5/13

SP

9.0	AN960JD516L	Washer
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
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1	AN960JD516L	Washer	M14477
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9/5/13

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Part Number: D3085041

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

MS21042L3

Nut



9/5/13



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description	Batch
3	MS21042L3	Nut(or MS21042-3)	M110844

sd

11.0

MS21042L4

Nut



9/5/13



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description	Batch
1	MS21042L4	Nut(or MS21042-4)	M110430

sd

12.0

MS27039113

Screw



9/5/13



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Screw

Pick:

Qty	Part Number	Description	Batch
3	MS27039-1-13	Screw	M105211

sd

13.0

SL69BS

Ball Stud



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Ball Stud

Pick:

Qty	Part Number	Description	Batch
1	SL69-BS	Ball Stud	M109239

9/5/13

sd

14.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D3085

EP09/05/13 (4)

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9/5/13

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Part Number: D3085041

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

PACKAGING 1

PACKAGING RESOURCE #1



(4X)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 271

9/5/20

50

17.0

QC21

FINAL INSPECTION/W/O RELEASE



09/05/20

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-05-20

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**NOTE:** Date & initial all entries

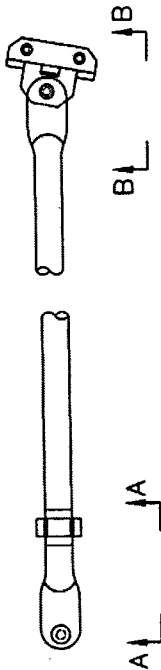


**DART**

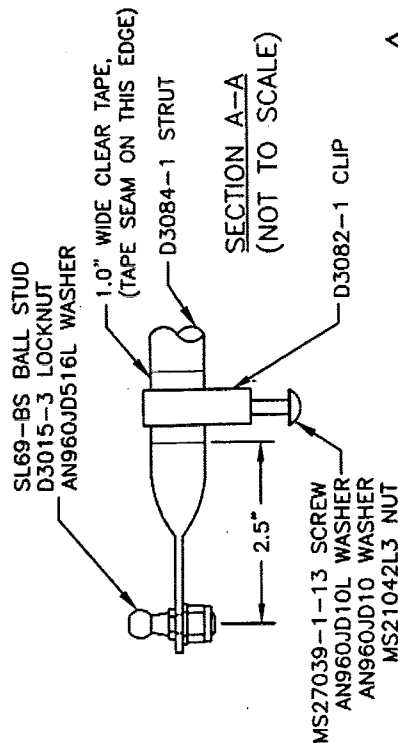


RELEASED  
02-01-25

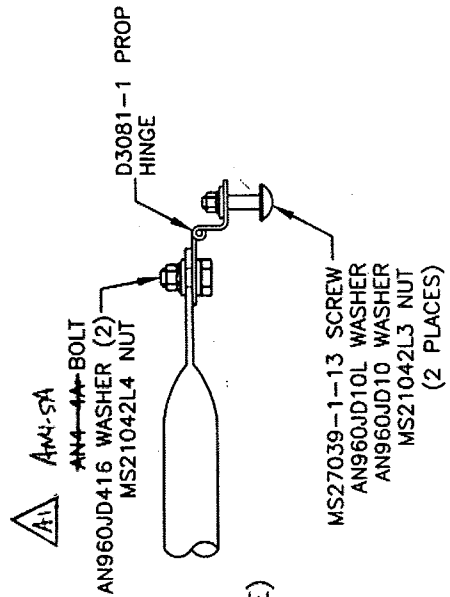
DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	APPROVED	#	DRAWING NO. D3085	REV. A SHEET 1 OF 1
DATE	02.01.23			TITLE PROP ARM ASSEMBLY	SCALE 1:5
A	02.01.23			NEW ISSUE	
A1	# CP 02.02.25			AN4-SA WAS AN4-4A	



D3085-041 PROP ARM ASSEMBLY



SECTION A-A  
(NOT TO SCALE)



SECTION B-B  
(NOT TO SCALE)

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